

5/43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24616
<b>Description:</b> Cover Assembly, RH	<b>Part Number:</b>	D3163-042
<b>Dwg:</b> D3163.Rev. B	<b>Qty:</b>	3
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler	[Signature]	05.10.25	3												
2	CA	<b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3163-1</td> <td>Plate</td> <td>B 24613</td> </tr> <tr> <td>1</td> <td>D3163-3</td> <td>Plate</td> <td>B 24614</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3163-1	Plate	B 24613	1	D3163-3	Plate	B 24614	[Signature]	05-10-25	3
Qty	Part Number	Description	Batch														
1	D3163-1	Plate	B 24613														
1	D3163-3	Plate	B 24614														
3	CA	Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>Sikaflex 241/291</td> <td>M 18467</td> </tr> </tbody> </table> <b>Expiry Date:</b> 12 Dec 2005	Qty	Part Number	Description	Batch	A/R	N/A	Sikaflex 241/291	M 18467	[Signature]	05-10-25	3				
Qty	Part Number	Description	Batch														
A/R	N/A	Sikaflex 241/291	M 18467														
4	QC5	Inspect bonding of D3163-1/-3	[Signature]	05.10.31	3												
5	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3	[Signature]	05 11 01	3												
6	QC3	Inspect Powder Coat	[Signature]	05-11-02	3												
7	CA	C'sink D3163-3 as per Dwg D3163. Touch up c'sink holes with alodine.	[Signature]	05-11-02	3												
8	CA	Assemble nut plate as per Dwg D3163 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>4</td> <td>MS20426AD3-4</td> <td>Rivet</td> <td>M15786</td> </tr> <tr> <td>2</td> <td>MS21059L08</td> <td>Nut Plate</td> <td>M10015</td> </tr> </tbody> </table> <b>Identify as D3163-042</b>	Qty	Part Number	Description	Batch	4	MS20426AD3-4	Rivet	M15786	2	MS21059L08	Nut Plate	M10015	[Signature]	05/11/02	3
Qty	Part Number	Description	Batch														
4	MS20426AD3-4	Rivet	M15786														
2	MS21059L08	Nut Plate	M10015														
9	QC5	Inspect work to current Step	[Signature]	05/11/03	3												
10	ST	Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock	[Signature]	05/11/03	3												
11	AC	Cost / part: 106.67	[Signature]	05-11-04	3												
12	DC	Close W/O 43.96 Inspect Level 21	[Signature]	05/11/04	3												

Rev	Date	Change	Revised By	Approved
A	05.10.25	New issue	KJ/RF	[Signature]

**RELEASED**  
 RF 05.10.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: SD Date: 05/11/04

NOTE: Date & initial all entries

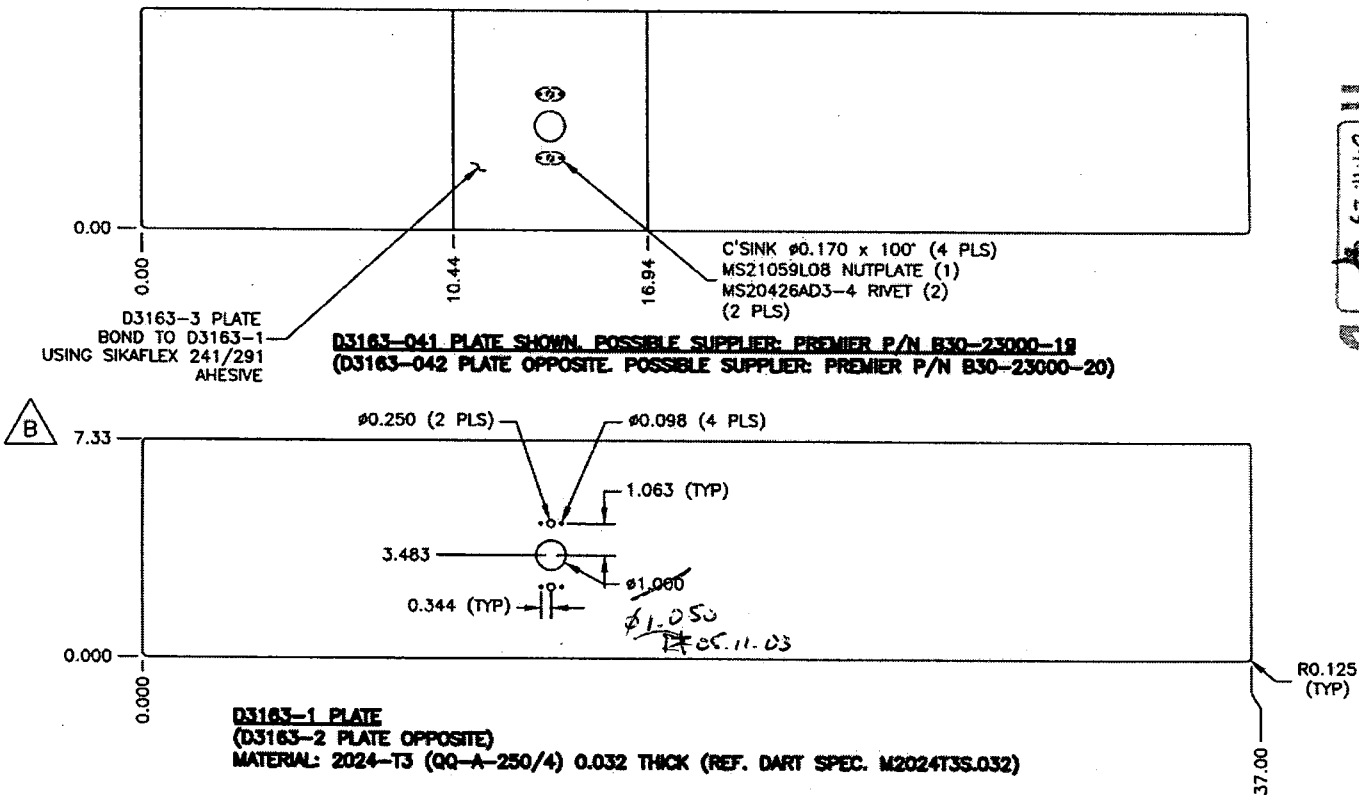
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**



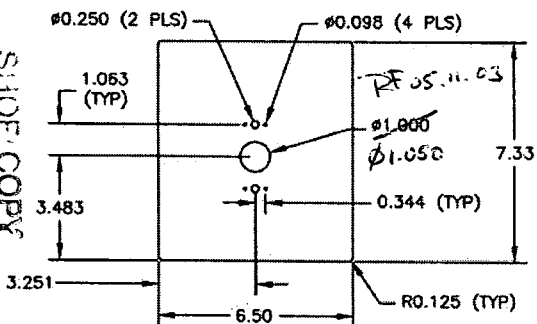
RELEASED  
04/11/23

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
04.10.06	D3163	SHEET 1 OF 1
	TITLE	SCALE
	PLATE	1:6
A	02.04.26	NEW ISSUE
B	04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19  
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

D3163-1 PLATE  
(D3163-2 PLATE OPPOSITE)  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)



D3163-3 PLATE  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOOT COPY  
RETURN TO  
ENGINEERING  
ATTACHED COPY  
CIT. COMMENT  
THOU. NOTICE  
WORK ORDER  
NO. 24616

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 19, 2005  
01:48 pm

Work Order No : 0024616  
Project Name : D3163-042  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3163-042  
Description : Cover Assembly RH  
Manufactured : Yes  
Amount Req'd : 83  
Amount Done : 0  
Start Date : 10-19-05  
Est Finish Date : 10-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00